

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001548**Date Inspected:** 01-Mar-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** **Yes No N/A****Rod Oven in Use:** **Yes No N/A****Electrode to specification:** **Yes No N/A****Weld Procedures Followed:** **Yes No N/A****Qualified Welders:** **Yes No N/A****Verified Joint Fit-up:** **Yes No N/A****Approved Drawings:** **Yes No N/A****Approved WPS:** **Yes No N/A****Delayed / Cancelled:** **Yes No N/A****Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Tim McClendon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

The QA inspector performed visual weld inspection on the following welds on production panel DP-018-002, weld # 4 on rib # U274 one (1) area incomplete fusion totaling 25mm and one (1) area of oversize weld totaling 60mm, weld # 5 on rib # U211 two (2) areas of underfilled weld was found totaling 11mm and one (1) area incomplete fusion totaling 5mm, weld # 6 on rib # U211 two (2) areas of underfilled weld was found totaling 11mm, weld #7 on rib # U189 two (2) areas of underfilled weld was found totaling 9mm and two (2) area of incomplete fusion was found totaling 55mm, weld # 8 on rib #U189 two (2) areas of underfilled weld totaling 35mm and three (3) areas of overlap totaling 2030mm and two areas of undercut was found totaling 25mm. The QA inspector also performed visual weld inspection on the following welds on production panel DP-061-001, weld # 1 on rib # U182 three (3) areas of under filled weld totaling 68mm, six (6) areas of incomplete fusion was found totaling 78mm and two (2) area of overlap was found totaling 65mm, weld # 2 on rib # U182 four (4) areas of underfill was found totaling 24mm, one (1) area of incomplete fusion was found totaling 8mm and one (1) area of over lap was found totaling 330mm, weld # 3 on rib # U178 one (1) area of oversize weld was found totaling 25mm eight (8) areas of incomplete fusion was found totaling 71mm, two (2) areas of underfilled weld was found totaling 15mm and one (1) area of overlap was found totaling 80mm,, weld #4 on rib # U178 four (4) areas of underfill was found totaling 164mm and one area of over lap was found totaling 480mm, weld #5 on rib # U181 seven (7) areas of underfill was found totaling 85mm.

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Visual Tracking Record is being maintained on site for reference and has been forwarded to the assistant structural materials representative Mr. Ady Velasco.

Summary of Conversations:

No relevant conversations spoken on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	McClendon,Timothy	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
